

NCR-19-7639



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5425-043

Job Sheet 195766



Part No: D5425-043

Job Qty: 1 pcs

Part Name: Float Skidtube Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/30/19

Job Tracking No:

Created By: Kimberley Guerin

Due Date: 7/5/19

Description:

Type: Stock

Note: DWG D5425 REV.B IPP REV:A 17.11.02 NEW ISSUE DD VERF:JFS IPP REV:B 18.08.20 AS PER DWG
REV.B DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - 1	1 pcs	7/5/19		0.00	8.24	Skidtubes - 1		
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		TF DD
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
120	HAAS 4 Axis - B4B	1 pcs	7/5/19		1.00	22.77	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		A.P. 19-06-25
130	QC 2	1 pcs	7/5/19		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		



Container No: S187890



Part: D5425-043

Job No: 195766

Serial No/Batch: S187890

Revision: B

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaero.com

Date: 08/05/19

Plex 5/30/19 10:42 AM Dart.Guerin.Kimberley

						QC 2 - 49	
						QC 2 - 50	
						QC 2 - 51	
						QC 2 - 52	
						QC 2 - 57	
						QC 2 - 62	
						QC 2 - 63	
						QC 2 - 8	B.a 19-06-25
						QC 2 - 66	
						QC 2 - 64	
						QC 2 - 65	
						QC 2 - 5	
						QC 2 - 71	
						QC 2 - 73	
						QC 2 - 69	
						QC 8 - 12	
						140 QC 8	1 pcs
QC 8 - 17							
QC 8 - 20							
QC 8 - 25							
QC 8 - 3							
QC 8 - 32							
QC 8 - 33							
QC 8 - 35							
QC 8 - 39							
QC 8 - 4							
QC 8 - 44							
QC 8 - 45							
QC 8 - 49	mm 19/06/25						
QC 8 - 58							
QC 8 - 8							
QC 8 - 9							
QC 8 - 68							
QC 8 - 67							
QC 8 - 1 (A)							
QC 8 - 47							
QC 8 - 40							
QC 8 - 52							
QC 8 - 23							
QC 8 - 57							
150 Handfinish - 1-1 Chemical-B4B	1 pcs	7/5/19	0.00	0.24	Handfinish - 1 - 1 - B4B		
					Handfinish - 1 - 2 - B4B	BB 55	
					Handfinish - 1 - 3 - B4B		
					Handfinish - 1 - 4 - B4B		
					Handfinish - 1 - 5 - B4B		
					Handfinish - 1 - 6 - B4B		
					Handfinish - 1 - 7 - B4B		
					Handfinish - 1 - 8 - B4B		
					Handfinish - 1 - 9 - B4B		
					Handfinish - 1 - 10 - B4B		
					Handfinish - 1 - 11 - B4B		
					Handfinish - 1 - 12 - B4B		
					Handfinish - 1 - 13 - B4B		
					Handfinish - 1 - 14 - B4B		
					Handfinish - 1 - 15 -		
						Plex 5/30/19 10:42 AM Dart.Guerin.Kimberley	

				B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
160 QC 7	1 pcs	7/5/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
170 Skidtubes - Bend - 2 - B4B	1 pcs	7/5/19	0.50 2.63	Skidtubes - Bend - B4B	
180 QC 5	1 pcs	7/5/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	

190 Skidtubes - 2 - B4B	1 pcs	7/5/19	0.00 8.24	QC 5 - 30	
				QC 5 - 40	
				Skidtubes - 1 - B4B	
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	
				Skidtubes - 4 - B4B	TF
				Skidtubes - 5 - B4B	
				Skidtubes - 6 - B4B	
200 QC 5	1 pcs	7/5/19	0.00 0.00	Skidtubes - 7 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
210 Handfinish - 6-1- Touch Up- B4B	1 pcs	7/5/19	0.00 0.24	QC 5 - 30	
				QC 5 - 40	
				Handfinish - 6 - 1 - B4B	
				Handfinish - 6 - 2 - B4B	
				Handfinish - 6 - 3 - B4B	
				Handfinish - 6 - 4 - B4B	
				Handfinish - 6 - 5 - B4B	
				Handfinish - 6 - 6 - B4B	
				Handfinish - 6 - 7 - B4B	
				Handfinish - 6 - 8 - B4B	
				Handfinish - 6 - 9 - B4B	
				Handfinish - 6 - 10 - B4B	
				Handfinish - 6 - 11 - B4B	
				Handfinish - 6 - 12 - B4B	
				Handfinish - 6 - 13 - B4B	
				Handfinish - 6 - 14 - B4B	
				Handfinish - 6 - 15 - B4B	
				Handfinish - 6 - 16 - B4B	
				Handfinish - 6 - 17 - B4B	
				Handfinish - 6 - 18 - B4B	
				Handfinish - 6 - 19 - B4B	
				Handfinish - 6 - 20 - B4B	
				Handfinish - 6 - 21 - B4B	
				Handfinish - 6 - 22 - B4B	

220 QC 7	1 pcs	7/5/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
230 Skidtubes - 3 - B4B	1 pcs	7/5/19	0.00 8.24	Skidtubes - 1 - B4B	
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	
				Skidtubes - 4 - B4B	
				Skidtubes - 5 - B4B	
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
240 QC 5	1 pcs	7/5/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
250 Handfinish - 6-2- Touch Up- B4B	1 pcs	7/5/19	0.00 0.00	Handfinish - 6 - 1 - B4B	
				Handfinish - 6 - 2 - B4B	
				Handfinish - 6 - 3 - B4B	
				Handfinish - 6 - 4 - B4B	
				Handfinish - 6 - 5 - B4B	
				Handfinish - 6 - 6 - B4B	
				Handfinish - 6 - 7 - B4B	

						Handfinish - 6 - 8 - B4B	
						Handfinish - 6 - 9 - B4B	
						Handfinish - 6 - 10 - B4B	
						Handfinish - 6 - 11 - B4B	
						Handfinish - 6 - 12 - B4B	
						Handfinish - 6 - 13 - B4B	
						Handfinish - 6 - 14 - B4B	
						Handfinish - 6 - 15 - B4B	
						Handfinish - 6 - 16 - B4B	
						Handfinish - 6 - 17 - B4B	
						Handfinish - 6 - 18 - B4B	
						Handfinish - 6 - 19 - B4B	
						Handfinish - 6 - 20 - B4B	
						Handfinish - 6 - 21 - B4B	
						Handfinish - 6 - 22 - B4B	
260 QC 7	1 pcs	7/5/19	0.00	0.00		QC 7 - 10	
						QC 7 - 13	
						QC 7 - 14	
						QC 7 - 15	
						QC 7 - 17	
						QC 7 - 18	
						QC 7 - 19	
						QC 7 - 2	
						QC 7 - 28	
						QC 7 - 3	
						QC 7 - 30	
						QC 7 - 34	
						QC 7 - 36	
						QC 7 - 37	
						QC 7 - 41	AG 19-7-13
						QC 7 - 47	
						QC 7 - 48	
						QC 7 - 51	
						QC 7 - 58	
						QC 7 - 59	
						QC 7 - 60	
						QC 7 - 9	
						QC 7 - 68	
						QC 7 - 50	
						QC 7 - 67	
						QC 7 - 40	
						QC 7 - 24	
						QC 7 - 43	
270 Spray Paint - 2 - B4B	1 pcs	7/5/19	0.00	0.00		Spray Paint - 1 - B4B	AG 19-7-13
						Spray Paint - 2 - B4B	
						Spray Paint - 3 - B4B	
						Spray Paint - 4 - B4B	
280 QC 14	1 pcs	7/5/19	0.00	0.00		QC 14 - 15	AG 19-7-13

						QC 14 - 2	
						QC 14 - 34	
						QC 14 - 41	
						QC 14 - 51	
						QC 14 - 58	
						QC 14 - 59	
						QC 14 - 9	
						QC 14 - 68	
						QC 14 - 40	
						QC 14 - 19	
						QC 14 - 43	
						QC 14 - 24	
282	Outsource - 11 - Paint	1 pcs	7/5/19			ATE003-VC	2
284	Packaging 2-1 - Receive - B4B	1 pcs	7/5/19	0.00	0.00	Packaging 2 - 1 - B4B	
							Packaging 2 - 2 - B4B
							Packaging 2 - 3 - B4B
							Packaging 2 - 5 - B4B
							Packaging 2 - 4 - B4B
							Packaging 2 - 6 - B4B
							Packaging 2 - 7 - B4B
							Packaging 2 - 8 - B4B
							Packaging 2 - 9 - B4B
							Packaging 2 - 10 - B4B
							Packaging 2 - 11 - B4B
							Packaging 2 - 12 - B4B
							Packaging 2 - 13 - B4B
							Packaging 2 - 14 - B4B
							Packaging 2 - 15 - B4B
							Packaging 2 - 16 - B4B
							Packaging 2 - 17 - B4B
							Packaging 2 - 18 - B4B
							Packaging 2 - 19 - B4B
							Packaging 2 - 20 - B4B
							Packaging 2 - 21 - B4B
							Packaging 2 - 22 - B4B
							Packaging 2 - 23 - B4B
							Packaging 2 - 24 - B4B
							Packaging 2 - 25 - B4B
							Packaging 2 - 26 - B4B
							Packaging 2 - 27 - B4B
							Packaging 2 - 28 - B4B
							Packaging 2 - 29 - B4B
							Packaging 2 - 30 - B4B
							Packaging 2 - 31 - B4B
							Packaging 2 - 32 - B4B
							Packaging 2 - 33 - B4B
							Packaging 2 - 34 - B4B
							Packaging 2 - 35 - B4B
							Packaging 2 - 36 - B4B
286	QC 6	1 pcs	7/5/19	0.00	0.00	QC 6 - 9	
							QC 6 - 68
							QC 6 - 61
							QC 6 - 40
290	Handfinish - 4-1-Assembly-B4B	1 pcs	7/5/19	0.00	0.24	Handfinish - 4 - 1 - B4B	14-7-12
							Handfinish - 4 - 10 - B4B
							Handfinish - 4 - 11 - B4B
							Handfinish - 4 - 12 -

				B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
300	QC 5	1	7/5/19	0.00 0.00	QC 5 - 10
		pcs			QC 5 - 12
					QC 5 - 17
					QC 5 - 18
					QC 5 - 19
					QC 5 - 22
					QC 5 - 24
					QC 5 - 3
					QC 5 - 43
					QC 5 - 49
					QC 5 - 51
					QC 5 - 58
					QC 5 - 68
					QC 5 - 9
					QC 5 - 50
					QC 5 - 30
					QC 5 - 40
310	Packaging 3-1 - Stock - B4B	1	7/5/19	0.00 0.00	Packaging 3 - 1 - B4B
		pcs			Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B

DAS

JUL 16 2019 40

9-89

					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	21
					Packaging 3 - 36 - B4B	21
320 QC 21 - SA	1	7/5/19	0.00	0.00	QC 21 - SA - 21	21
	pcs				QC 21 - SA - 70	21
					QC 21 - SA - 53	21

JUL 23 2019

JUL 23 2019

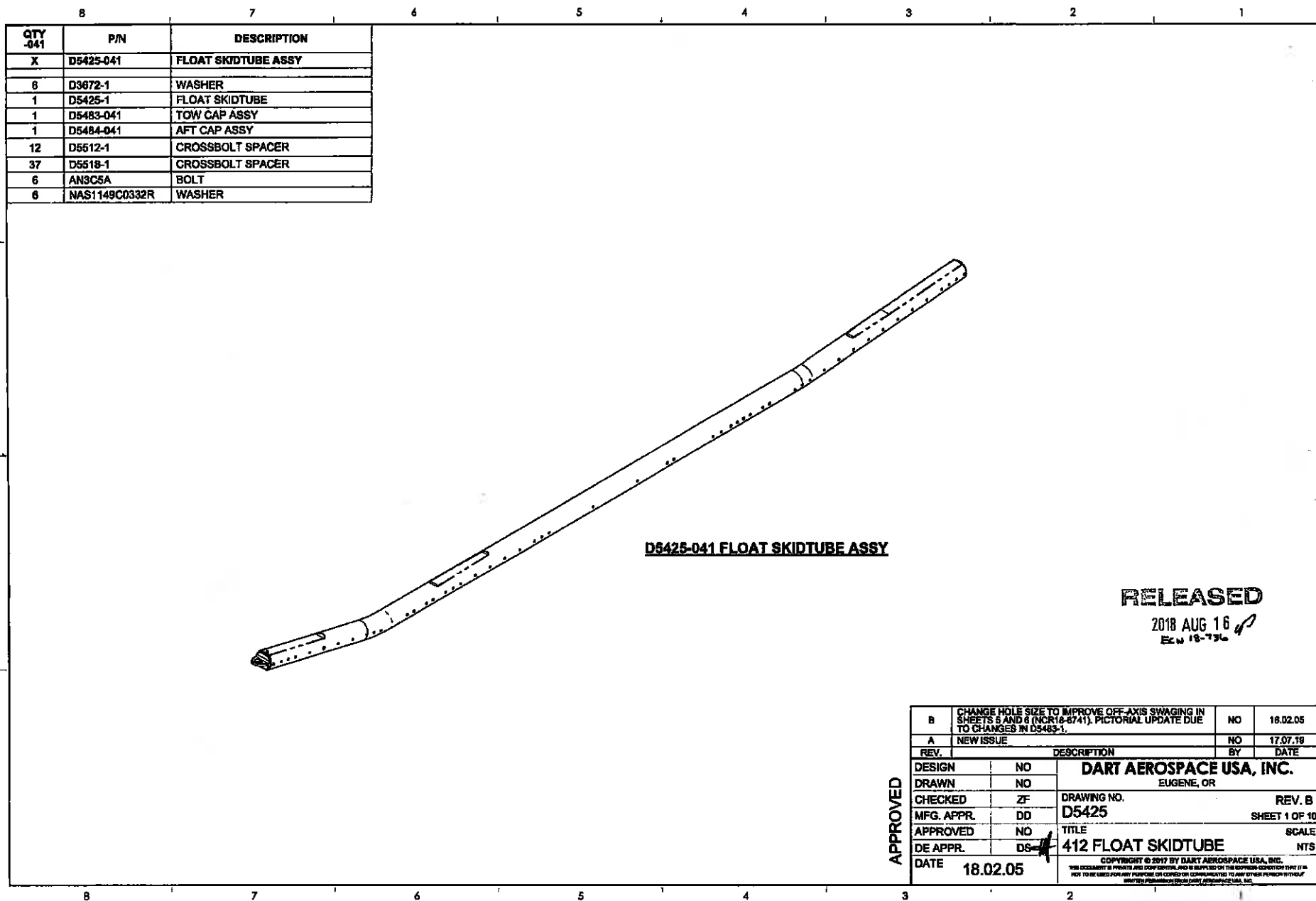
Part Op 110 - 1-Cut tube to finished length as per Dwg. 2-Deburr ends as per Dwg.
 Descriptions: 120 - 1-Machine as per Dwg. and Folio FB536 DWG REV: B FOLIO REV: AA 2-Deburr as per Dwg.
 130 - (QC2- Inspect parts off machine FAI/FAIB)
 140 - (QC8- Inspect parts - second check)
 150 - 1-Scrub inside of tube with medium scotchbright.
 160 - (QC7-Inspect Chemical Conversion Coat)
 170 - 1-Bend Aft end of tube as per Dwg. and Folio 4.5 Insert Bending mandrel DT 10328 at 20.0" from aft end. Use buggy A,B,C. to stabilize tube. HEIGHT 4.5 2-Bend Forward end of tube as per Dwg. and Folio 7.5 Insert Bending mandrel DT 10328 at 12.0" from fwd end. Use buggy A,B,C To stabilize tube. HEIGHT 7.5 3-Record dimensions on work order.
 180 - (QC5- Inspect part completeness to step on W/O)
 190 - 1-Drill remaining holes of DETAIL M, N, P. USING DT10340 A,B,C,D 2-Open holes to finished size as per Dwg. 3-Deburr holes per QSI002 section 4.2.3 and blow out all chips from inside of tube.
 200 - (QC5- Inspect part completeness to step on W/O)
 220 - (QC7-Inspect Chemical Conversion Coat)
 230 - 1-Wet Install crossbolt spacers of Section G-G. Swage to 0.437 as per Dwg. PRIMER B 5188698 Start Time: 5:18 Finish Time: 5:18 ***CURE TIME 6HRS. BEFORE PROCEEDING TO NEXT STEP*** 2-Swage crossbolt spacers of Section F-F to 0.313 as per Dwg. 3-Trim / Grind flush, deburr. 4-Identify per QSI 044 6.1
 240 - (QC5- Inspect part completeness to step on W/O)
 250 - (Touch up alodine) ***DO NOT SUBMERGE TUBE IN DEOXODIZER***
 260 - (QC7-Inspect Chemical Conversion Coat)
 270 - (Spray Paint / NDT Room) ***PLUG ALL CROSSBOLT SPACER HOLES PRIOR TO PRIME AND PAINT*** 1-PRIME AS PER DWG AND QSI005 4.2.1.3.3 PRIMER BATCH: 5188698 2-PAINT AS PER DWG AND QSI005 4.2.2.4 PAINT BATCH: 5188698
 280 - (QC14- Inspect Spray Paint)
 282 - ***PLUG ALL CROSSBOLT SPACER HOLES PRIOR TO PRIME AND PAINT*** 1-PRIME AS PER DWG AND QSI005 4.2.1.3.3 PRIMER BATCH: 5188698 2-PAINT AS PER DWG AND QSI005 4.2.2.4 PAINT BATCH: 5188698
 284 - C OF C IS REQUIRED
 290 - (Assemble as per dwg) 1-Install FWD and AFT cap seal with sikaflex-241 / 291 B 5188698 Exp: 5188698 Start time: 5:18 Finish time: 5:18 2-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser. A/R LPS Procyon B 5188698
 300 - (QC5- Inspect part completeness to step on W/O)
 310 - (Identify as per dwg & Stock Location: 5188698)
 320 - (QC21- Final Inspection - Work Order Release)

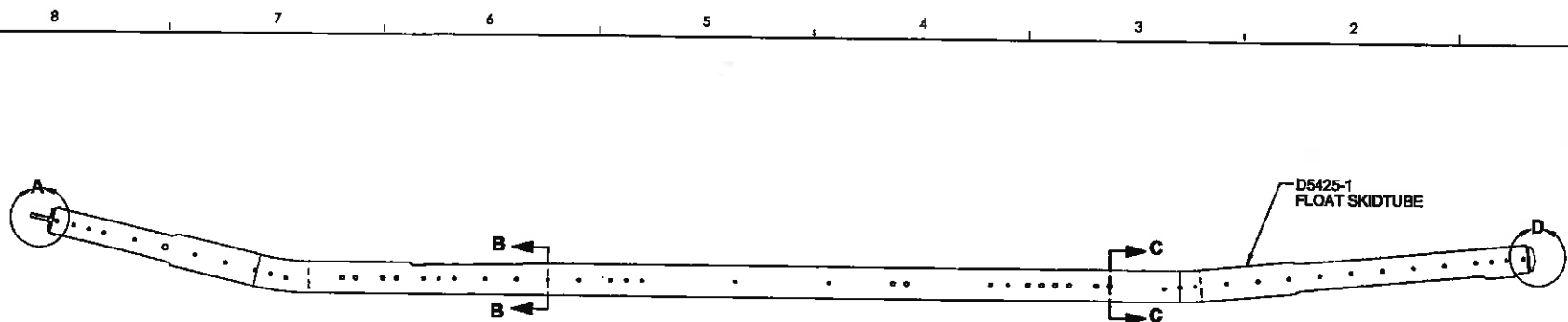
Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6028-195	Crosstube Material, 7075-T73/T73511	1 pcs (1 ea)	110-Skidtubes - 1	010 888
D5518-1	Crossbolt Spacer	18 pcs (18 ea)	230-Skidtubes - 3 - B4B	5188698
D5512-1	Crossbolt Spacer	12 pcs (12 ea)	230-Skidtubes - 3 - B4B	5188698
AN3C5A	Bolt	6 Ea (6 ea)	290-Handfinish - 4-1-Assembly-B4B	5188698
D3672-1	Washer, Phenolic	6 pcs (6 ea)	290-Handfinish - 4-1-Assembly-B4B	5188698
D5483-041	Tow Cap Assembly	1 pcs (1 ea)	290-Handfinish - 4-1-Assembly-B4B	5188698
D5484-041	Aft Cap Assembly	1 pcs (1 ea)	290-Handfinish - 4-1-Assembly-B4B	5188698
NAS1149C0332R	Washer	6 Ea (6 ea)	290-Handfinish - 4-1-Assembly-B4B	5188698

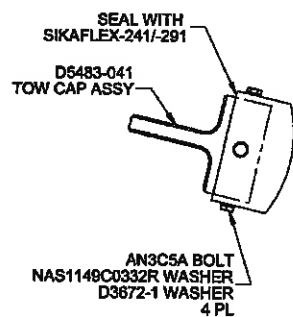
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D6028-195	1	0	0
230-Skidtubes - 3 - B4B	D5512-1	12	42	0
	D5518-1	18	272	0
290-Handfinish - 4-1-Assembly-B4B	AN3C5A	6	1,224	0
	D3672-1	6	1,727	0
	D5483-041	1	10	0
	D5484-041	1	9	0
	NAS1149C0332R	6	3,344	0
Part Specifications				
Specifications could not be found.				

Plex 5/30/19 10:42 AM Dart.Guerin.Kimberley

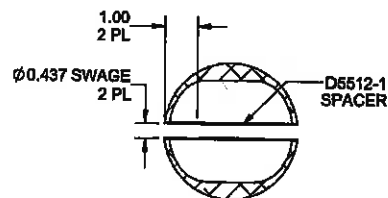




D5425-041 FLOAT SKIDTUBE ASSY

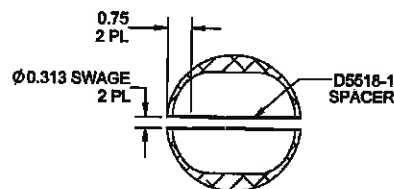


DETAIL A
SCALE 4X



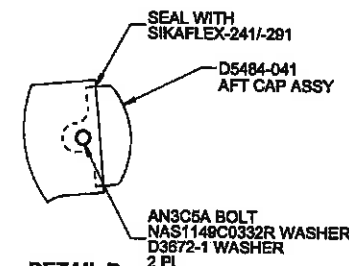
AFTER DRILLING AND BENDING, PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. WET INSTALL D5512-1 SPACER PER QSI 002
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

SECTION C-C
SCALE 4X
12 PL



AFTER DRILLING AND BENDING, PERFORM THE FOLLOWING FOR Ø0.377 HOLES ONLY:
1. INSERT D5518-1 SPACER
2. SWAGE TO Ø0.313 X 0.75 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

SECTION B-B
SCALE 4X
37 PL



DETAIL D
SCALE 4X

RELEASED

2018 AUG 16

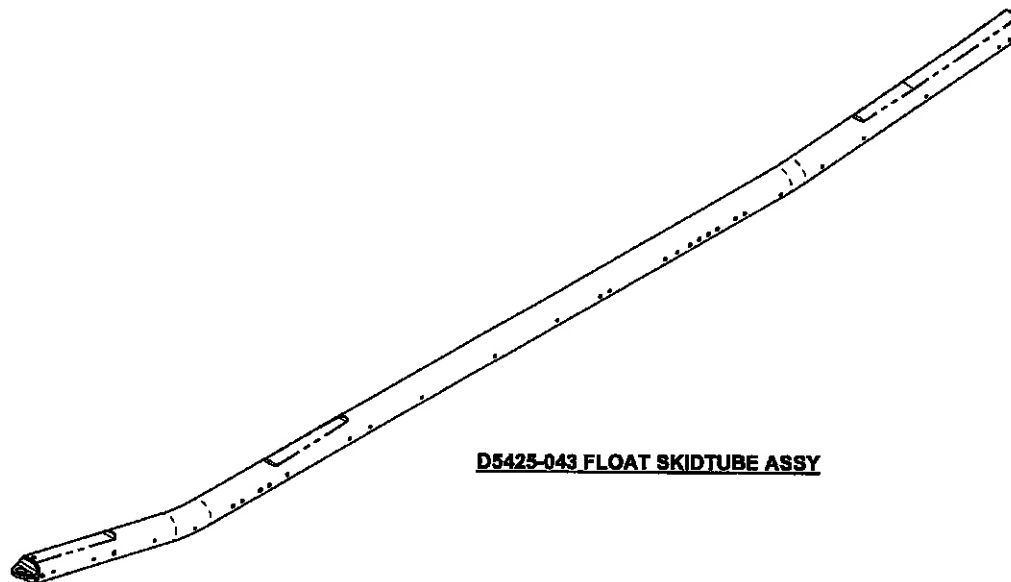
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME PER DART QSI 005 4.2.1.3.3
PAINT PER DART QSI 005 4.2.2.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 64.5lbs
- 8) COAT ALL EXPOSED FASTENERS WITH LPS "LPS PROCYON"

APPROVED

DESIGN	NO	DART AEROSPACE USA, INC.	
DRAWN	NO	EUGENE, OR	
CHECKED	ZF	DRAWING NO.	REV. B
MFG. APPR.	DD	D5425	SHEET 2 OF 10
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	412 FLOAT SKIDTUBE	NTS
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QTY -043	P/N	DESCRIPTION
X	D5425-043	FLOAT SKIDTUBE ASSY
6	D3672-1	WASHER
1	D5425-3	FLOAT SKIDTUBE (DART TRIBAG)
1	D5483-041	TOW CAP ASSY
1	D5484-041	AFT CAP ASSY
12	D5512-1	CROSSBOLT SPACER
18	D5518-1	CROSSBOLT SPACER
6	AN3CSA	BOLT
6	NAS1148C0332R	WASHER

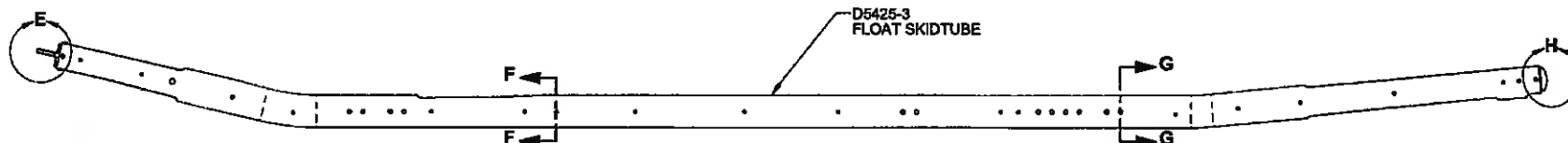


D5425-043 FLOAT SKIDTUBE ASSY

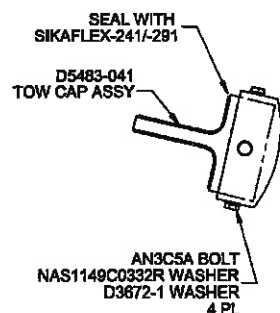
RELEASED

2018 AUG 16 *JP*

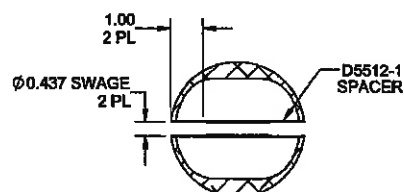
APPROVED	DESIGN	NO	DART AEROSPACE USA, INC. EUGENE, OR	
	DRAWN	NO		
	CHECKED	ZF	DRAWING NO.	REV. B
	MFG. APPR.	DD	D5425	SHEET 3 OF 10
	APPROVED	NO	TITLE	SCALE
	DE APPR.	D3	412 FLOAT SKIDTUBE	NTS
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D5425-043 FLOAT SKIDTUBE ASSY

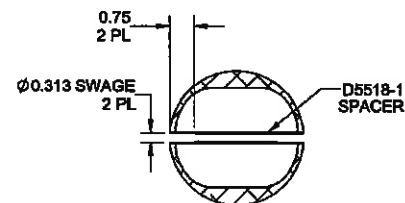


DETAIL E
SCALE 4X



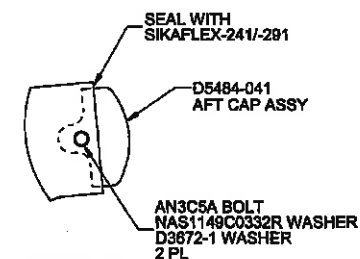
AFTER DRILLING AND BENDING, PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. WET INSTALL D5512-1 SPACER PER QSI 002
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

SECTION G-G
SCALE 4X
12 PL



AFTER DRILLING AND BENDING, PERFORM THE FOLLOWING FOR Ø0.377 HOLES ONLY:
1. INSERT D5518-1 SPACER
2. SWAGE TO Ø0.313 X 0.75 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

SECTION F-F
SCALE 4X
18 PL



DETAIL H
SCALE 4X

RELEASED

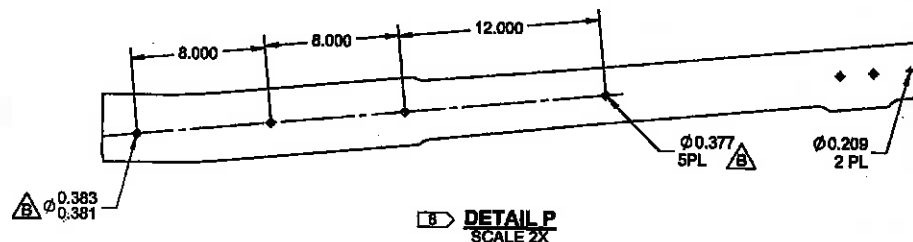
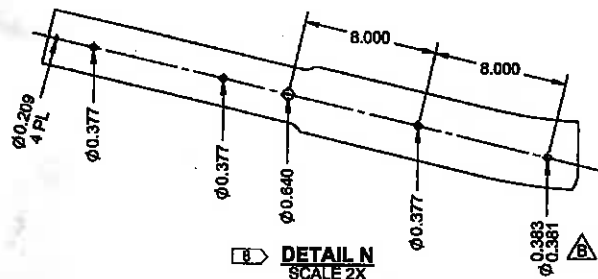
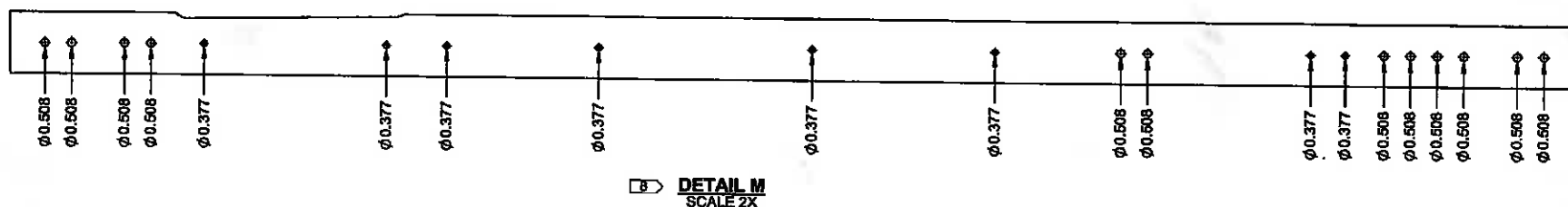
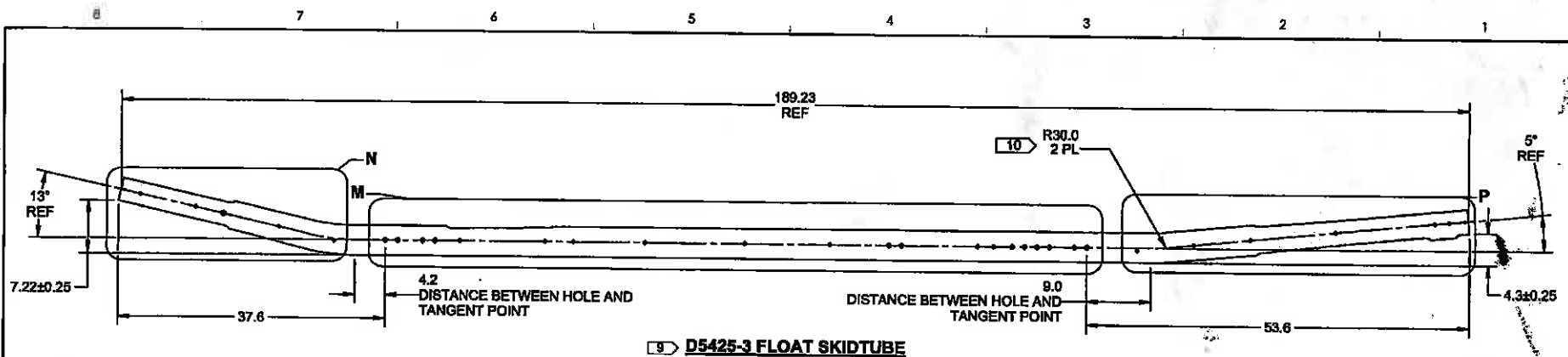
2018 AUG 16

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME PER DART QSI 005 4.2.1.3.3
PAINT PER DART QSI 005 4.2.2.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 54.3lbs
- 8) COAT ALL EXPOSED FASTENERS WITH LPS "LPS PROCYON"

APPROVED

DESIGN	NO	DART AEROSPACE USA, INC.	
DRAWN	NO	EUGENE, OR	
CHECKED	ZF	DRAWING NO.	REV. B
MFG. APPR.	DD	D5425	SHEET 4 OF 10
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NOTES:

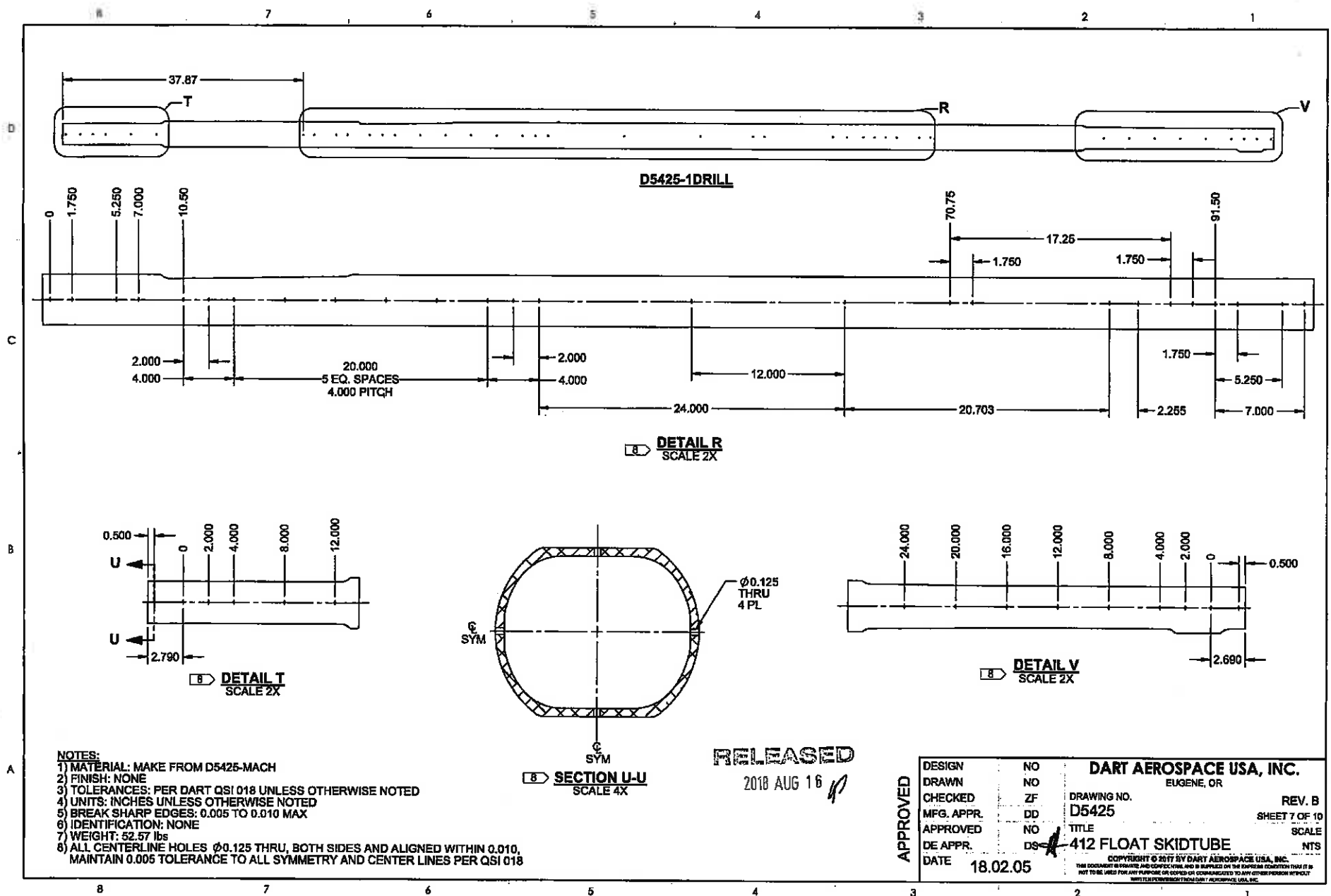
- 1) MATERIAL: MAKE FROM D5425-3DRILL
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 52.57 lbs
- 8) ALL HOLES THRU, BOTH SIDES AND ALIGNED WITHIN 0.010
- 9) MAXIMUM TWIST ALLOWANCE 3° BETWEEN FWD AND AFT BEND, 3° FROM EXTRUSION CENTERLINE AT ANY POINT
- 10) MAXIMUM 5% CRUSHING PER QSI 038 7.1

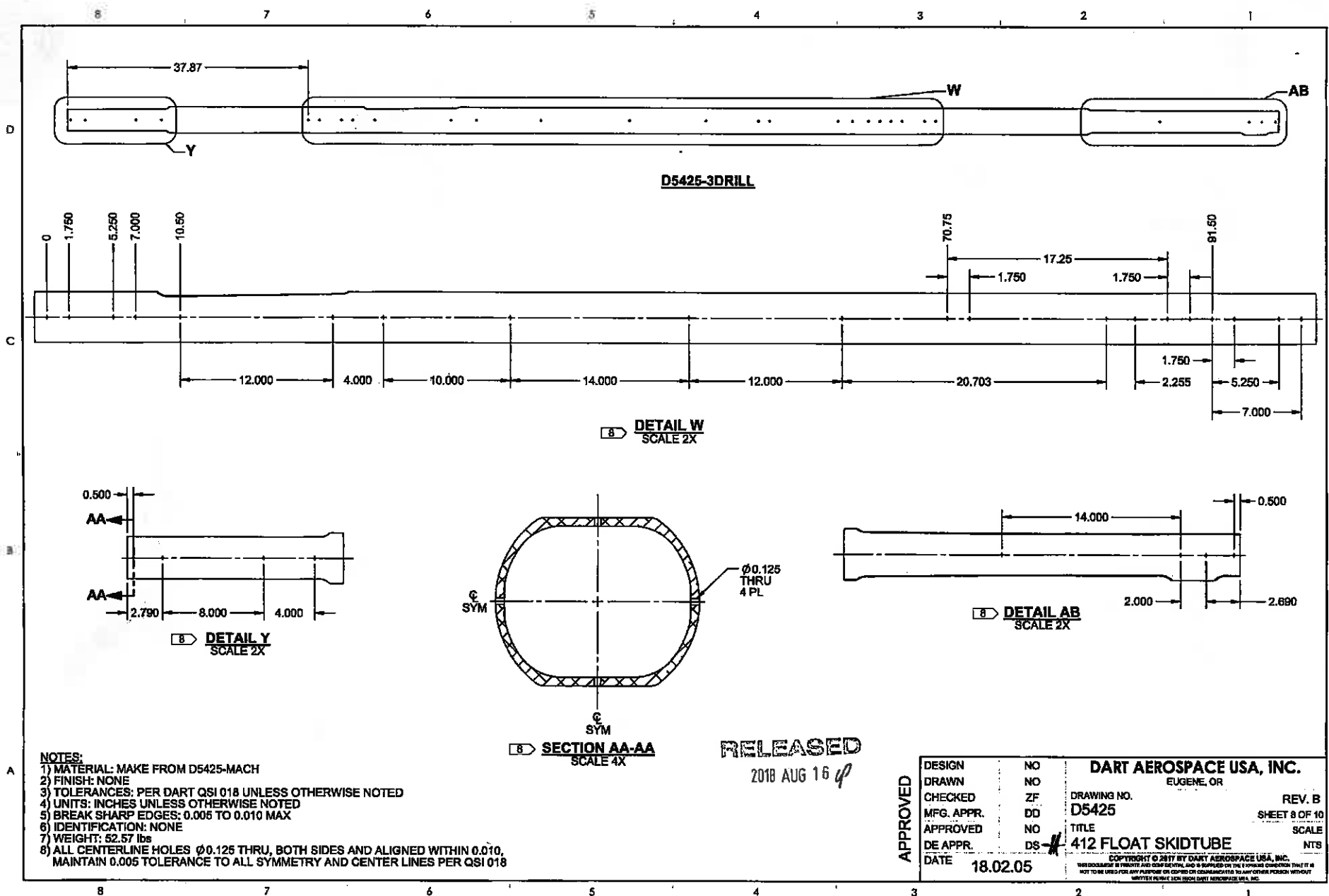
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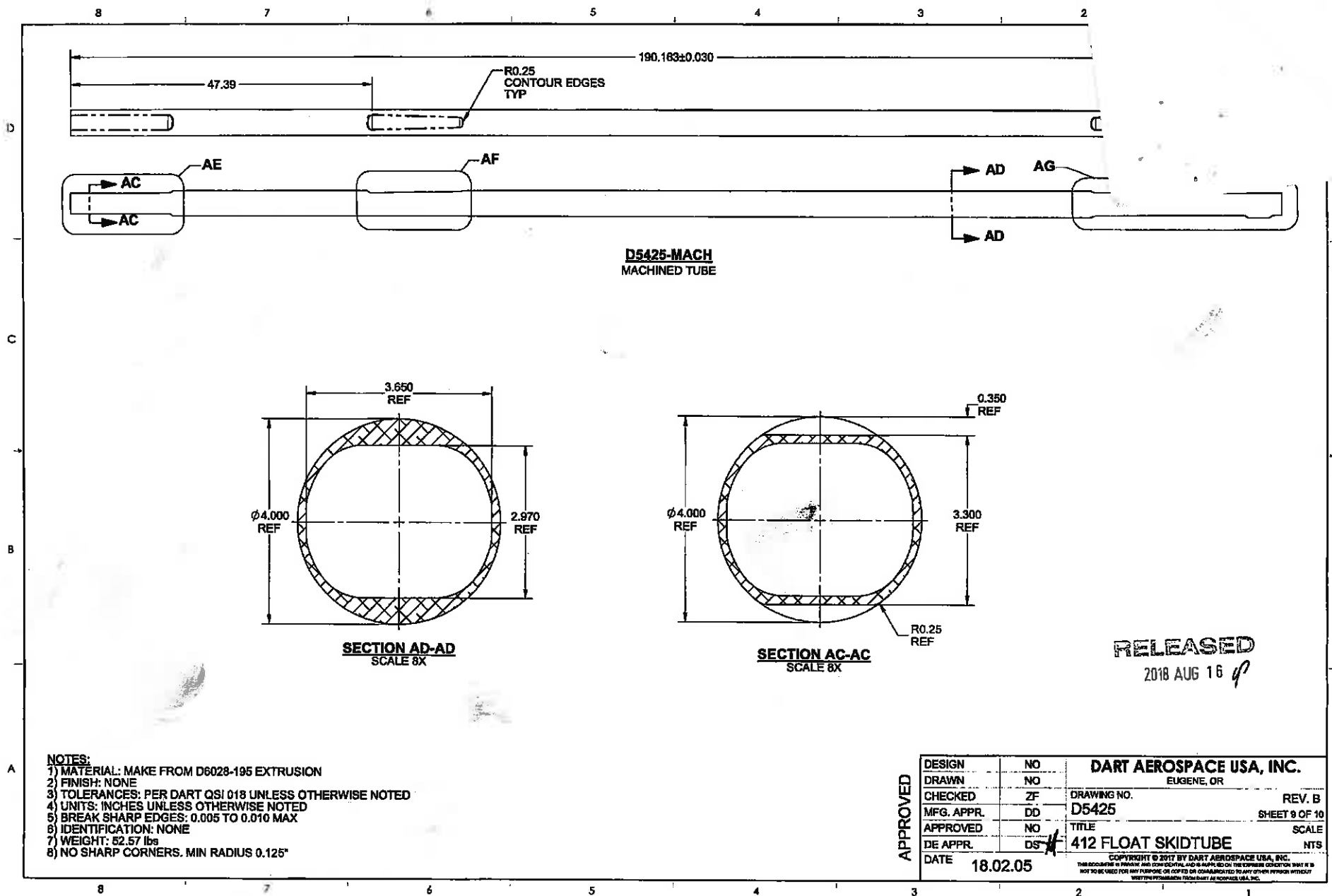
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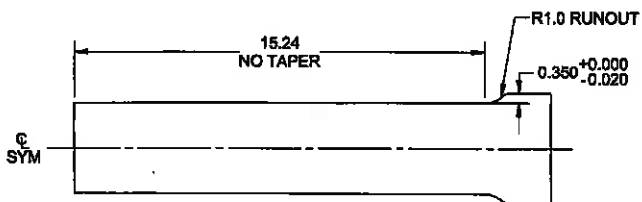
DESIGN	NO	DART AEROSPACE USA, INC.	
DRAWN	NO	EUGENE, OR	
CHECKED	ZF	DRAWING NO.	REV. B
MFG. APPR.	DD	D5425	SHEET 8 OF 10
APPROVED	NO	TITLE	SCALE
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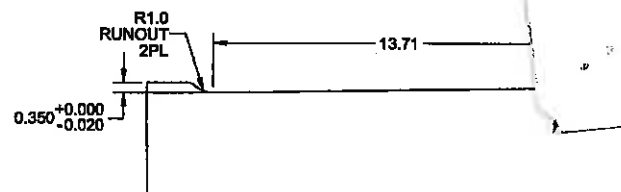




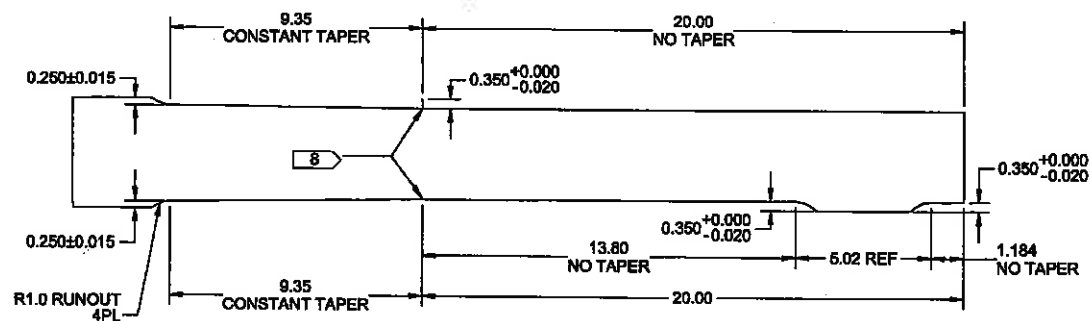
8 7 6 5 4 3



DETAIL AE
SCALE 3X



DETAIL AF
SCALE 3X



DETAIL AG
SCALE 3X

RELEASED
2018 AUG 16

APPROVED	DESIGN	NO	DART AEROSPACE USA, INC.	
	DRAWN	NO	EUGENE, OR	
	CHECKED	ZF	DRAWING NO.	REV. B
	MFG. APPR.	DD	D5425	SHEET 10 OF 10
	APPROVED	NO	TITLE	SCALE
	DE APPR.	DSS	412 FLOAT SKIDTUBE	NTS
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8 7 6 5 4 3 2

DART AEROSPACE LTD		Work Order: 195.766
Description: 412 FLOAT SKIDTUBE		Part Number: D5425-3
Inspection Dwg: D5425 Rev: B		Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.500	+/- .010	0.500	✓		Vern	GA-13
2.790	+/- .010	2.790	✓		Dial ind	HAAS4
10.790	+/- .010	10.790	✓		"	"
14.790	+/- .010	14.790	✓		"	"
43.120	+/- .010	43.116	✓		"	"
44.870	+/- .010	44.866	✓		"	"
48.37	+/- .010	48.366	✓		"	"
60.37	+/- .010	60.366	✓		"	"
64.37	+/- .010	64.366	✓		"	"
74.37	+/- .010	74.366	✓		"	"
123.328	+/- .010	123.324	✓		Tape	REF.
125.87	+/- .010	125.866	✓		"	"
129.37	+/- .010	129.366	✓		"	"
131.12	+/- .010	131.116	✓		"	"
134.62	+/- .010	134.616	✓		"	"
136.37	+/- .010	136.366	✓		"	"
0.500	+/- .010	0.500	✓		Dial ind.	HAAS4
2.690	+/- .010	2.690	✓		"	"
4.69	+/- .010	4.690	✓		"	"
18.69	+/- .010	18.690	✓		"	"
15.24	+/- .030	15.240	✓		Tape	ref.
R1.0	+/- .100	R1.000	✓		R-6	ref.
0.350	+ .000 / - .020	0.341	✓		Dial ind.	HAAS4
0.350	+ .000 / - .020	0.349	✓		"	"
R1.0	+/- .100	R1.000	✓		R-6	ref.
13.71	+/- .030	13.710	✓		Tape	ref.
0.152	+/- .015	0.153	✓		Dial ind	HAAS4
0.250	+/- .015	0.246	✓		"	"
9.35	+/- .030	9.350	✓		Tape	ref.
0.350	+ .000 / - .020	0.344	✓		Dial ind	HAAS4
20.00	+/- .030	20.000	✓		Tape	REF.
0.250	+/- .015	0.245	✓		Dial ind.	HAAS4

Measured by: B.A	Checked by: mmc	QC Inspector:
Date: 19-06-25	Date: 19/06/25	Date:

Engineering Approval: (if necessary)	Date:
--	--------------

Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

2R Date: Oct 28/19.

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE



W.O. No. 19-7639

Route update only ☐

Job: 195766	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒	DEPARTMENT/PROCESS			
Part No. D5425-043		Skid-tube ☒ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐

Date: 2019-07-08	Sequence #:	QTY Affected: 1	MRB (QS1042)
------------------	-------------	-----------------	--------------

Description Work Order Deviation	Disposition	
Fwd Bent @ 7.570" allowable = 7.47" overall twist 0.427" (3.4°) drag allowable 3°	Lowest margin near fwd bend is 0.25 (MS3ult, SR-D412-742-2), and is not affected by bend height. Increased float drag load by 1.3% does not change the critical condition. Extrusion twist is below 1°, bending twist of 3.4° does not have a significant effect on sectional properties and is acceptable as is.	N.O. 2019/07/08 Completed By Lead hand / Supervisor QC / QA Coordinator DAS 68 9-89 16 2019

Root Cause Operator ☐ Manufacturing Process ☒ Equip/Tooling ☒ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐	FAULT CATEGORY			
	☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled Other/Details:	☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up	☐ Positioned Wrong ☒ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread